



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4653-11

Job Sheet 201736



Part No: D4653-11

Job Qty: 24 pcs

Part Name: Clamp



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/9/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/24/19

Description:

Type: SOLD

Note: DWG REV A SHEET 9 IPP REV:A 12/06/12 NEW ISSUE JFS VERIFIED BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Bandsaw - 1	24 pcs	10/24/19	10/24/19	0.00	0.01	Bandsaw - 1	SBL 14/10/22
110	HAAS 4 Axis - B4B	24 pcs	10/24/19	10/24/19	0.09	13.04	HAAS - 1 - B4B	
							HAAS - 2 - B4B	SBL 14/10/22
							HAAS - 3 - B4B	
							HAAS - 4 - B4B	
120	QC 2	24 pcs	10/24/19	10/24/19	0.00	0.00	QC 2 - 1	SBL 14/10/22
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	



Container No: S224937



Part: D4653-11

Job No: 201736

Serial No/Batch: S224937

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/22/19

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				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130	QC 8	24 pcs	10/24/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
140	Packaging 3-1 - Stock - B4B	24 pcs	10/24/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B

DAS
52
9-89
19/10/23

Pc ST 224

				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150	QC 21 - SA	24 pcs	10/24/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

DAS
21
9-89

OCT 24 2019

Part Op 100 - CUT BLANK AT 3.025"

Descriptions: 110 - (HAAS CNC Vertical Machine), MACHINE AS PER DWG & FOLIO FB119

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Identify as per dwg & Stock Location: _____)

150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELINB1.000X4.000	Delrin Bar	6.0480 ft (.252 ea)	100-Bandsaw - 1	5178110 x 6.297p

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	MDELINB1.000X4.000	6	21	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clamp	1.080Inches ± 0.030	1.110 1.050	Radius	1.0735
2	Clamp	1.200Inches ± 0.030	1.230 1.170	Radius	1.199
3	Clamp	1.450Inches ± 0.030	1.480 1.420	Radius	1.450
4	Clamp	0.280Inches ± 0.030	0.310 0.250		0.282
5	Clamp	0.030Inches ± 0.030	0.060 0.000		0.031
6	Clamp	45.000Degrees ± 0.500	45.500 44.500		45°
7	Clamp	0.030Inches ± 0.030	0.060 0.000	Radius	R0.032
8	Clamp	0.020Inches ± 0.030	0.050 (0.010)		0.018
9	Clamp	45.000Degrees ± 0.500	45.500 44.500		45°
10	Clamp	0.032Inches ± 0.010	0.042 0.022	Radius	0.032
11	Clamp	0.015Inches ± 0.010	0.025 0.005		0.017
12	Clamp	45.000Degrees ± 0.500	45.500 44.500		45°
13	Clamp	0.850Inches ± 0.030	0.880 0.820		0.853
14	Clamp	0.130Inches ± 0.030	0.160 0.100		0.130
15	Clamp	0.060Inches ± 0.030	0.090 0.030		0.062
16	Clamp	0.120Inches ± 0.030	0.150 0.090		0.115
17	Clamp	2.250Inches ± 0.030	2.280 2.220	Diameter	2.250
18	Clamp	0.130Inches ± 0.030	0.160 0.100		0.130
19	Clamp	0.100Inches ± 0.030	0.130 0.070		0.098
20	Clamp	0.300Inches ± 0.030	0.330 0.270		0.304
21	Clamp	0.150Inches ± 0.030	0.180 0.120		0.153
22	Clamp	2.430Inches ± 0.030	2.460 2.400	Diameter	2.430

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐
Part No. _____	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐
	Use-as-is ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐
					Quality ☐
Date: _____	Sequence #: _____	QTY Affected: _____			
Description Work Order Deviation		Disposition			
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			
Root Cause		FAULT CATEGORY			
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐	
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐	
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐	
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐	
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐		
Human Factors ☐	Other/Details: _____				